

Work Order ID 128691***128691***

Page 1

Thursday, January 22, 2015 10:26:02 AM

Item ID: \ D206-642-441

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00

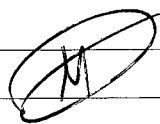
1

Customer:

Reference:

Approvals:

Process Plan:



Date: 1-22 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F(DEO)

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc. Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-441 CHG005

N/A MWS 15-04-27

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Start Date: 1/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod **M130137/M13082 BE 15-1-28**4-Grind weld flush to cap on top surface only. **BE 15-1-28**

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open aft cap holes using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail

12-Deburr and Blow out all chips from inside the tube

DGL 15-1-27**DGL 15-1-29.**

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

115

QC

Memo

Quality Control

DAS
03
9-89

① 15-2-2

116	QC10- Inspect visual per QSI004- ground welds	0.00							
-----	---	------	--	--	--	--	--	--	--

116

QC

Memo

Quality Control

DAS
9
9-89

① 15-02-02

120	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

120

HandFinish

Memo

Hand Finishing

15-2-2 *AK/DEL*

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Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC7-Inspect Chemical Conversion Coat

0.00

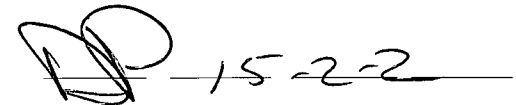
130

QC

Memo

0.00

Quality Control

DAS
03
9-89

140

Skidtubes

0.00

140

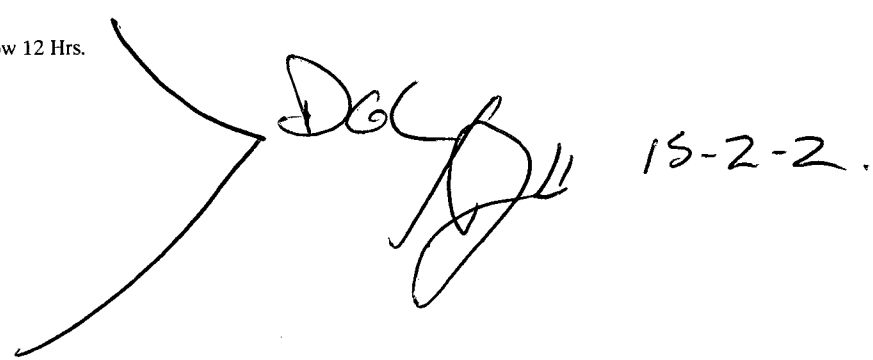
Skidtubes

Memo

0.00

Skidtubes

1-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 4:00 pm
Time: _____Finish Date: _____
Time: _____A/RSikaflex-291 131120
Sikaflex expiry date: 15-10-21

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150						1	0	15-02-03	
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Skidtubes					1	0	15-2-30	
Skidtubes	Memo	0.00							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
170		0.00							
170	HandFinishing					1	0	15-2-30	
Skidtubes	Memo	0.00							
Skidtubes	Install D2680-041 Nut Plate as per Dwg D2650								

DAS
18
9-89

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Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

38
9-89

13-02-10

200

Pressure Wash per QSI005 4.3

0.00

200

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 0 15-2-20

DGC
JH

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Memo

M 131545.

0.00

Powder Coating

Make Sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

1 0 15-4-15.

DAS 34 9-89

START TIME:

9:30

OVEN TEMPERATURE:

320°

FINISH TIME:

10:00.

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1

Customer:

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220 QC3- Inspect Part Finish

0.00

220

0.00

QC

Memo

Quality Control

1x	6	HL	15/01/20
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DAS
15
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00						
230	HandFinishing							
HandFinish	Memo	0.00						
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>M131571</u> Sikaflex expiry date: <u>15110</u>							
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive <u>RTU 598 M125792</u> <u>24115106</u>							
	3-Install MS27039-4-06 Screw as per DEO 9153							
	4-Inspect for foreign object per QSI 024							
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>M131571</u> Sikaflex expiry date: <u>1516</u>							
	6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 Batch: <u>M131588</u>							

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Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
240									
QC	Memo	0.00							APR 22 2015
Quality Control									
250	Packaging	0.00							
250									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

131733
DAS
06
9-89

APR 23 2015

MLJ 150427

MLJ 15-04-24

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Work Order ID: 128691

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Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
10.09.27 SS washers for wearplates EC verf:DD IPP Rev:L 12.11.22 now
swage per ecn12-679 DD verf:JLM IPP REV:M 14.04.25 AS PER
ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4956-15		Manufactured	No				Each	26.0000		1			
D4956-15									**			15/04/20	
Wearplate Fwd													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		26							
				124078		13							
				126458		13							
D4956-23		Manufactured	No				Each	19.0000		1			
D4956-23									**			15/04/20	
Wearplate Center Fwd													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		19							
				124079		8							
				126459		11							
D4956-37		Manufactured	No				Each	5.0000		1			
D4956-37									**			13/04/20	
Wearplate Aft													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		5							
				119666		5		B128763					

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Work Order ID: 128691

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Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

D2620	Manufactured	No	110	Each	13.0000	1	1
-------	--------------	----	-----	------	---------	---	---

D2620

Skidtube, 206 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	13	
126930	13	

DGL 15-1-27
(1)

D2647	Manufactured	No	110	Each	10.0000	1	1
-------	--------------	----	-----	------	---------	---	---

D2647

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	10	
114961	10	

BE 15-01-28
1

D2654-7	Manufactured	No	140	Each	1.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D2654-7

Web

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	1	
109327	1	

DGL 15-2-2
(1)

D4720-1	Manufactured	No	160	Each	358.0000	23	23
---------	--------------	----	-----	------	----------	----	----

D4720-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	358	
114878	358	

15-2-3
(23)

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D206-642-441

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Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3 CCR264SS-3-03 Purchased No

170 Each

83.0000

2 2

CCR264SS3-3

Cherry Rivet

**

15-2-3 JK

Location

Loc Qty

Loc Code

FP001

40

m126333

40

ST321

43

113073

23

m128818

20

(2)

D2680-041 Manufactured No

170 Each

21.0000

1 1

D2680-041

Nut Plate

**

15-2-3 JK

Location

Loc Qty

Loc Code

LG001

21

115056

21

(1)

ALS4-1032-130 AELS4-1032-130 Purchased No

230 Each

3,327.000

60 60

ALS4-1032-130

Rivnut

**

15104120

ALS4-1032-130

Location

Loc Qty

Loc Code

CA

1617

M128649

1617

FP001

639

M128649

639

st549

1071

M128649

1071

X60

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Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

807.0000

2

2

CR3212-4-03

Cherry Rivet

**

15-2-3

Location

Loc Qty

Loc Code

CCK004

700

119017

700

FP001

7

m123265

7

LG001

38

m123265

38

ST320

62

m114859

62

(2)

D2646

Manufactured

No

230

Each

16.0000

1

1

D2646

Aft Cap

**

11 15/01/20

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

1

114495

6

119656

5

B120761

xl

D2651-1

Manufactured

No

230

Each

173.0000

22

22

D2651-1

Plug

**

11 15/01/20

Location

Loc Qty

Loc Code

FP001

173

112725

117

114496

56

B128795

X15 X15 X15

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Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

230

Each

758.0000

22

22

D2651-3

O-Ring

**

ll 15/04/20

Location

Loc Qty

Loc Code

FP001

758

113577

16

120110

742

x22

D3537-1

Manufactured No

230

Each

43.0000

6

6

D3537-1

Wearpad

**

ll 15/04/20

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

B131358

x6

FP001

25

126306

4

126307

21

D3537-3

Manufactured No

230

Each

43.0000

1

1

D3537-3

Wearpad

**

ll 15/04/20

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

35

120646

35

x1

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Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

230

Each

1,400.000

2

2

MS27039-1-08

all 1/30/15/20

Screw

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

516

m128636

516

GA

2

125654

2

ST285

786

m128636

786

x2

MS27039-4-06

Purchased

No

230

Each

39.0000

1

1

MS27039-4-06

all 1/30/15/20

Screw

Location

Loc Qty

Loc Code

FP001

7

m126534

7

ST283

32

m126534

32

x1

MS27039C1-08

Purchased

No

230

Each

1,170.000

60

60

MS27039C1-08

all 1/30/15/20

SCREW

Location

Loc Qty

Loc Code

ST273A

731

m128650

731

ST283

439

m128650

439

x60

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Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,069.000

60

60

NAS1149C0332R

WASHER

Handwritten: 1/31/04/20

Location

Loc Qty

Loc Code

FP001

2182

Handwritten: 11131697

Handwritten: x60

m130325

2182

GA

26

125654

26

ST271

861

m130466

861

NAS1149D0332J

Purchased

No

230

Each

1,831.000

2

2

NAS1149D0332J

Washer

Handwritten: 1/31/04/20

Location

Loc Qty

Loc Code

CA

14

Handwritten: 11131621

Handwritten: x2

m129682

14

FP001

17

m130325

17

ST269

1800

m130325

1800

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Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

230

Each

5,041.000

1

1

NAS1149D0463.J

Handwritten: 12/04/20

WASHER

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1167

16941

14

M129390

1153

ST269

3069

M129390

12

M130799

3057

Handwritten: 1132035

Handwritten: X1

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

15-1-22
128691

DEO ATTACHED
RELEASED
08.07.23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

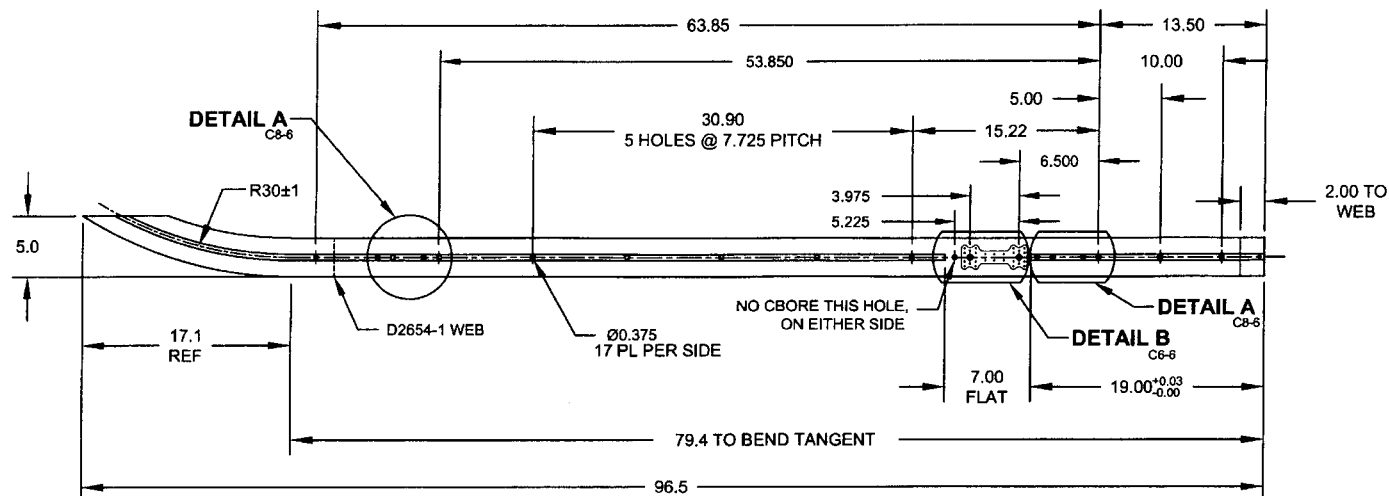
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

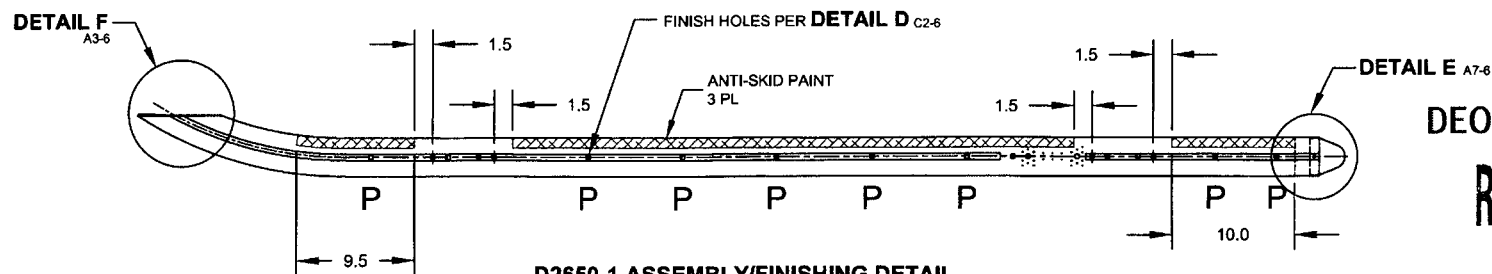
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--



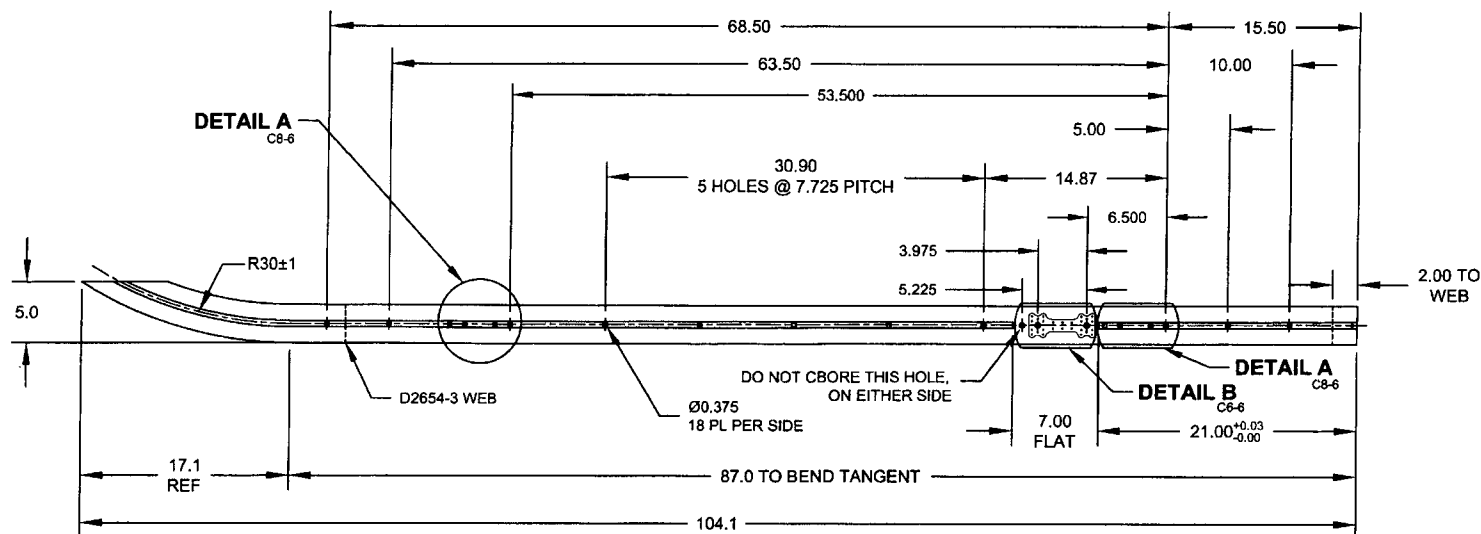
D2650-1 BENDING/DRILLING DETAIL



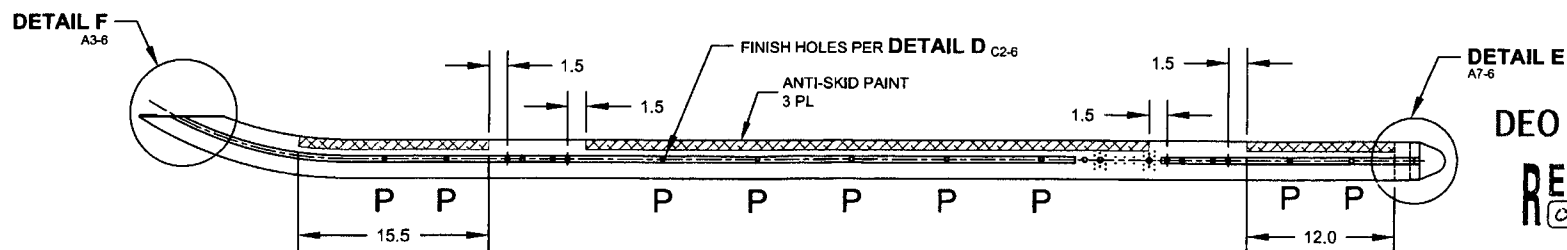
D2650-1 ASSEMBLY/FINISHING DETAIL

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RELEASED
680922/14

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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D2650-3 BENDING/DRILLING DETAIL



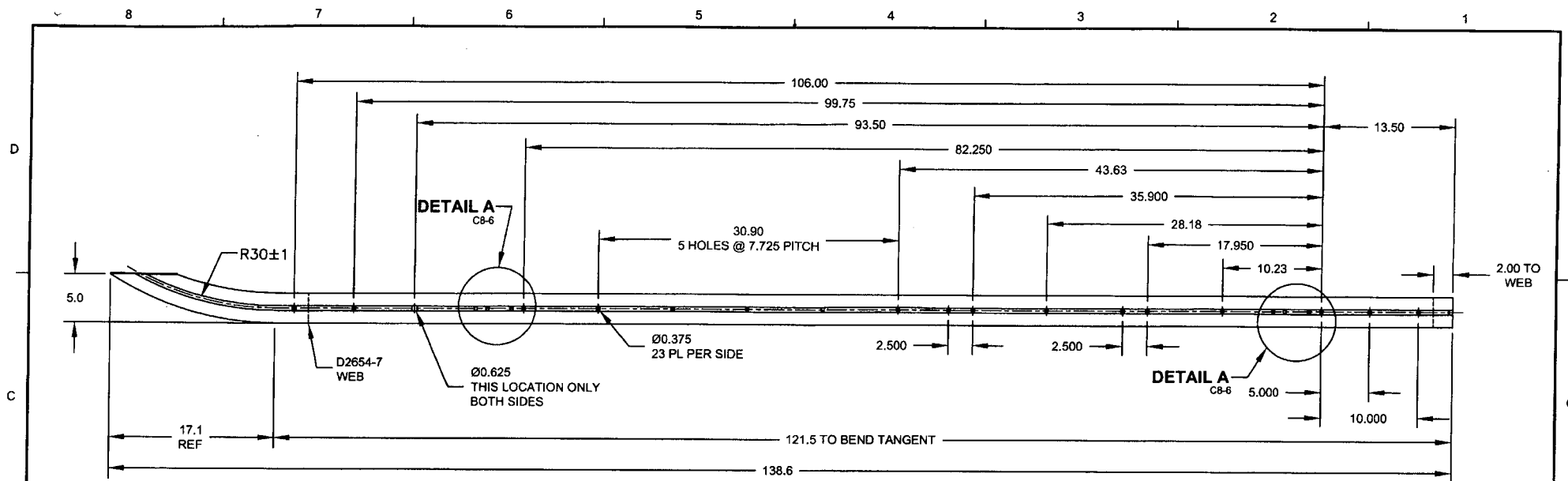
D2650-3 ASSEMBLY/FINISHING DETAIL

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08-07-22-1118

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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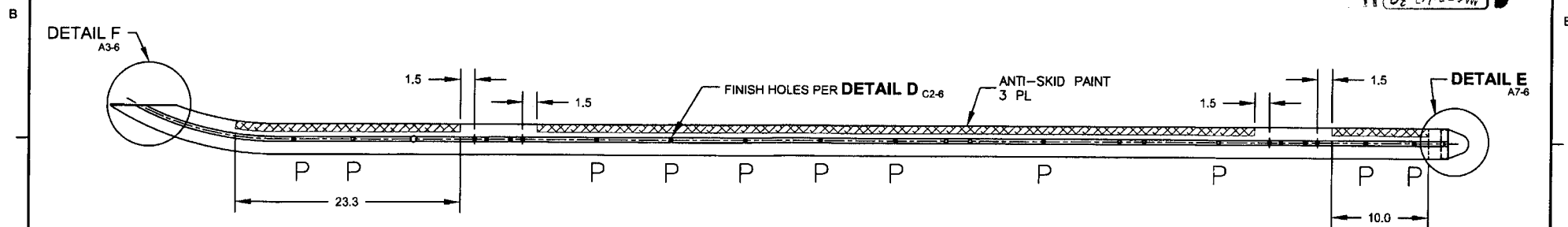
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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D2650-7 BENDING/DRILL DETAIL

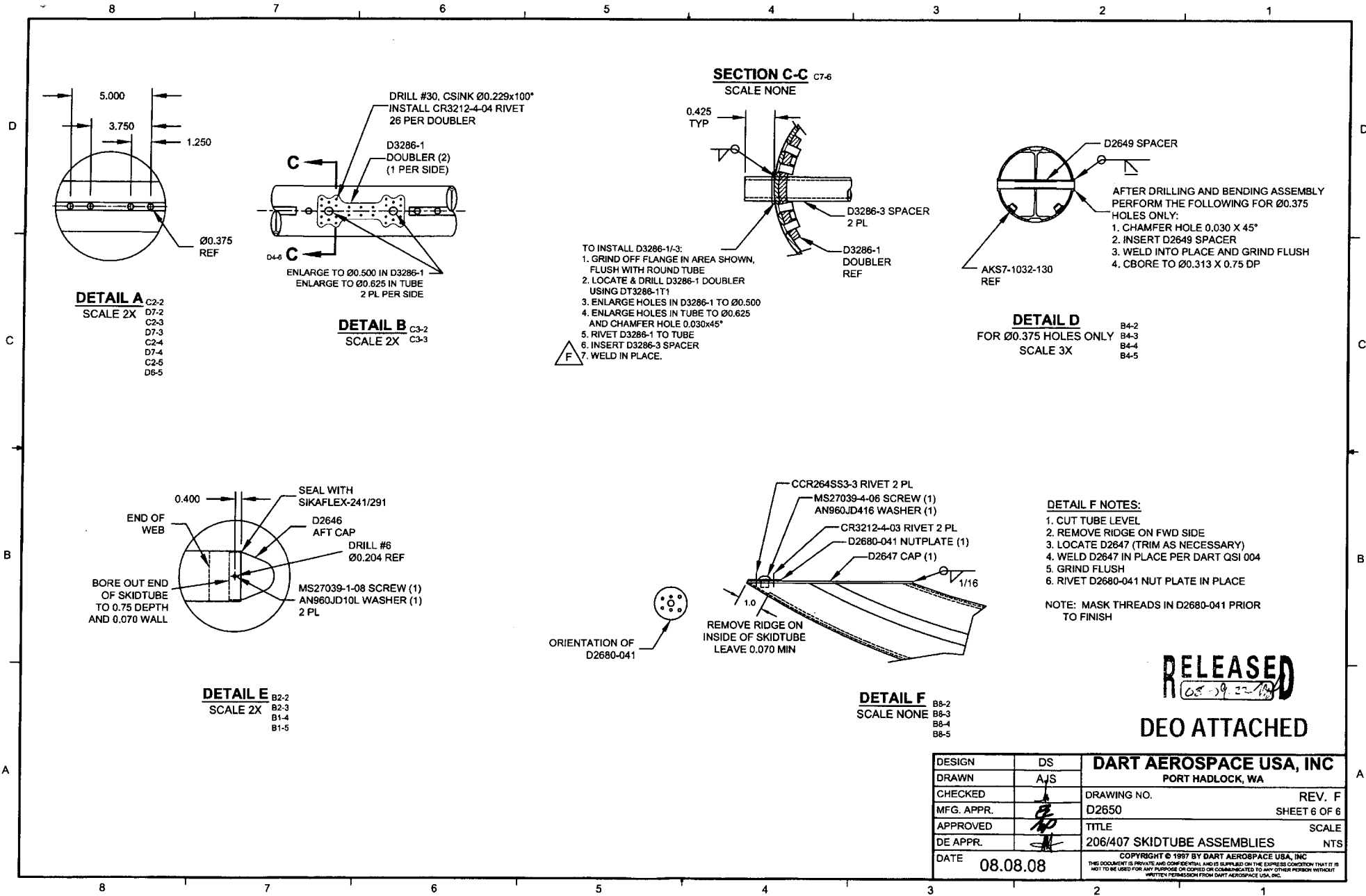
DEO ATTACHED

RELEASE
04 07 22 1971



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

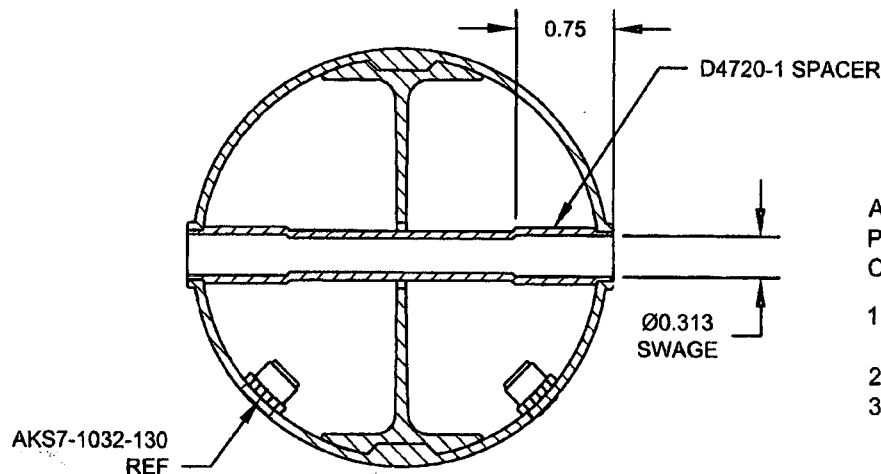
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

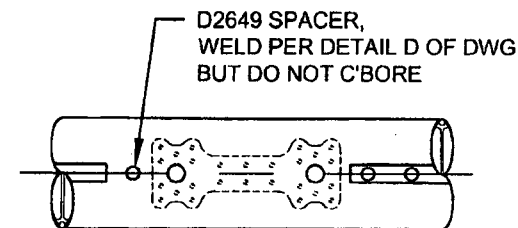
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002